

FIG. 1

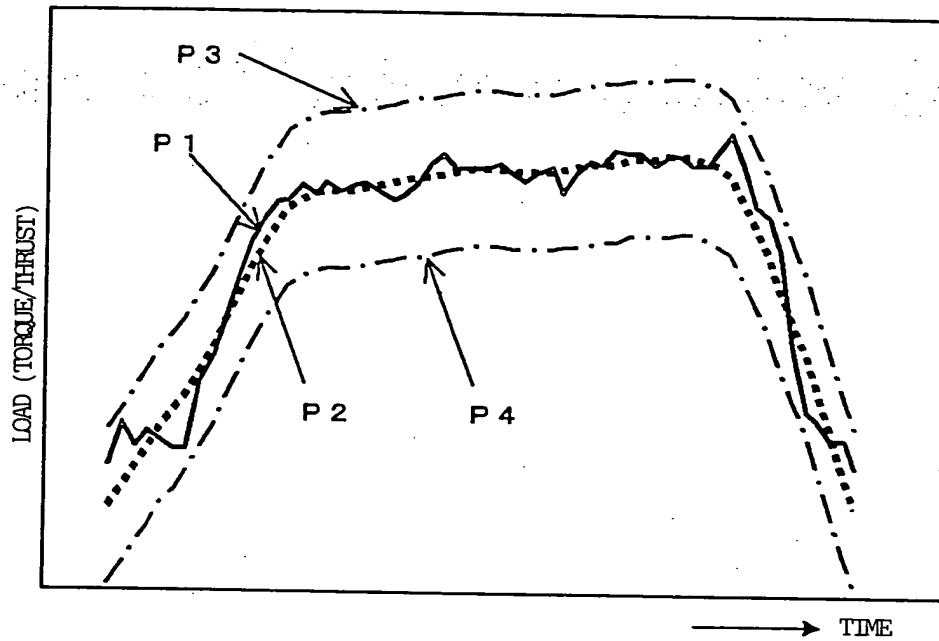


FIG. 2

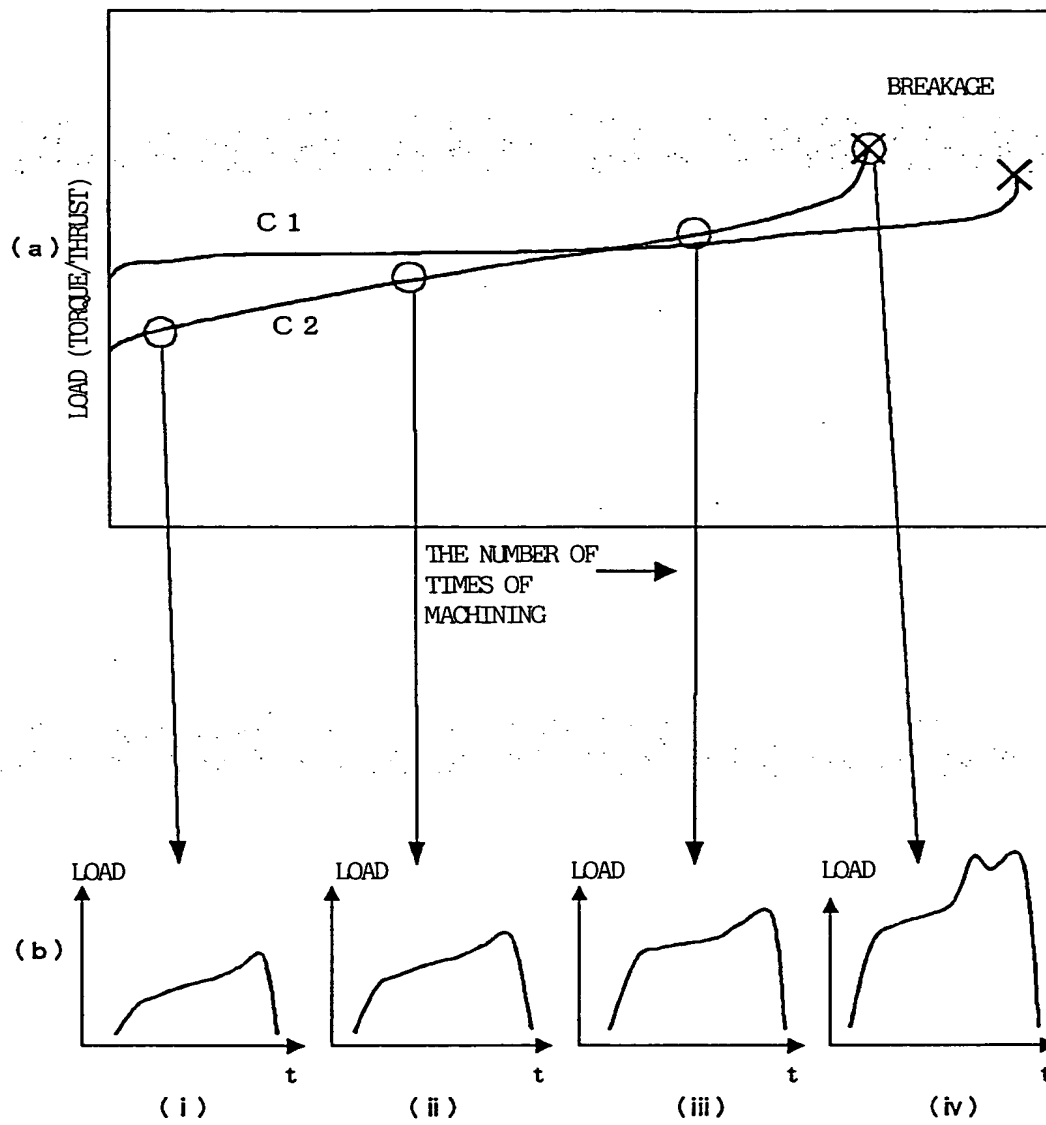
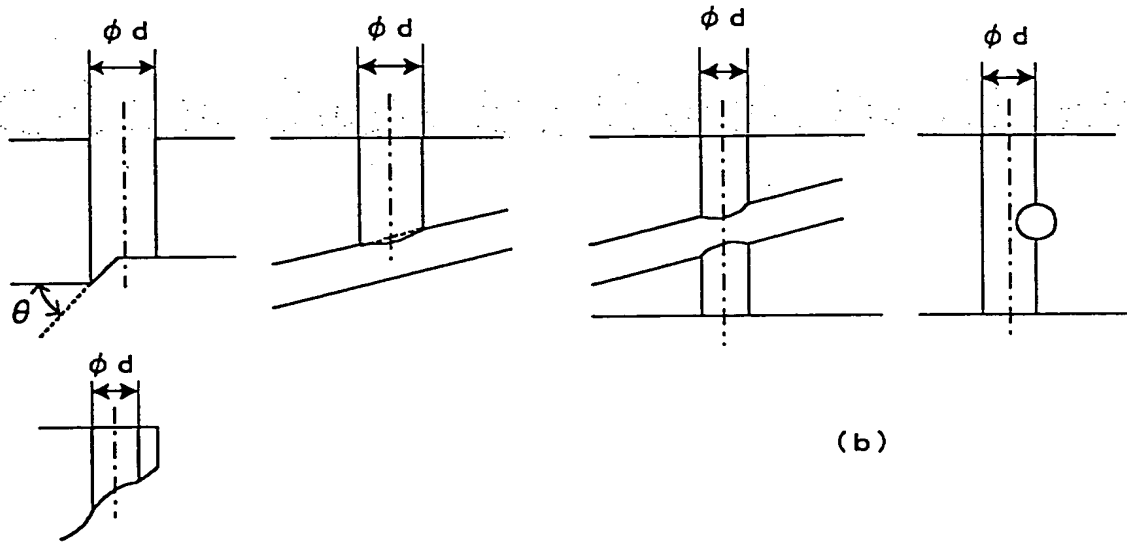
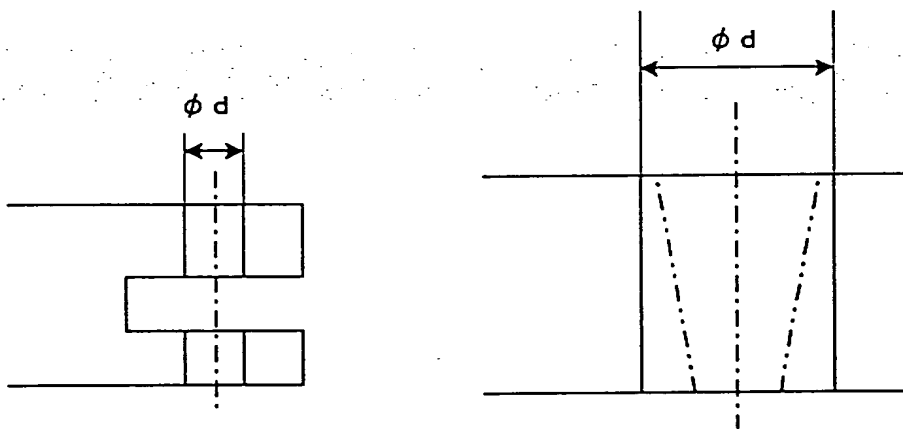


FIG. 3



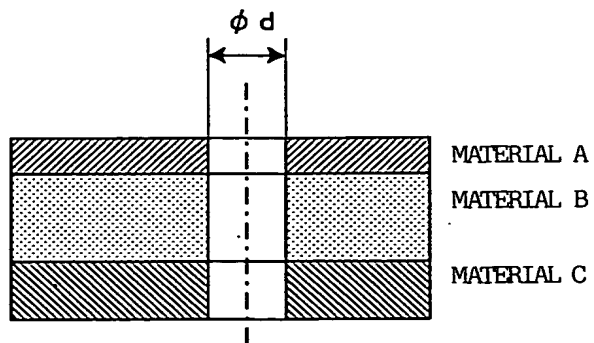
(a)

(b)



(c)

(d)



(e)

FIG. 4

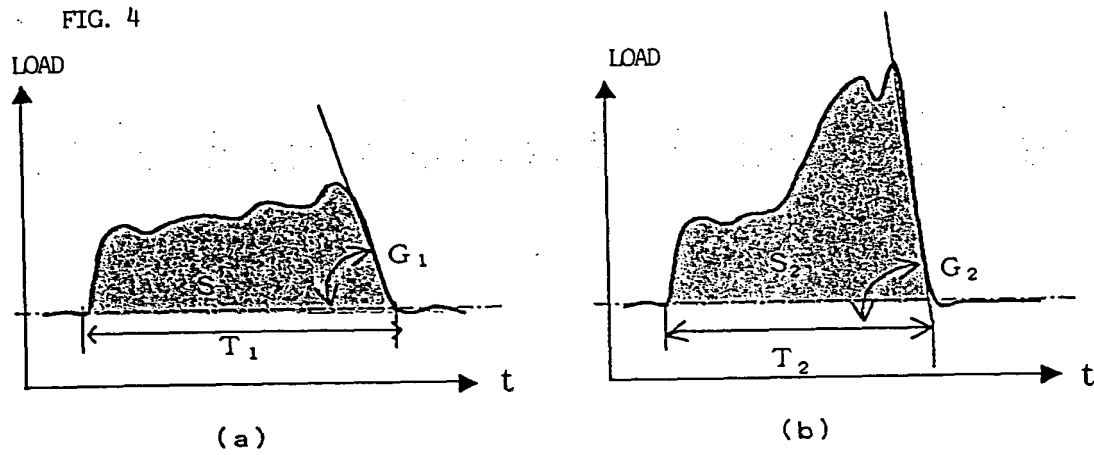


FIG. 5

$\phi 2.5$ CARBIDE DRILL · S50C · S8000 · F3200

—●— Z AXIS LOAD TORQUE

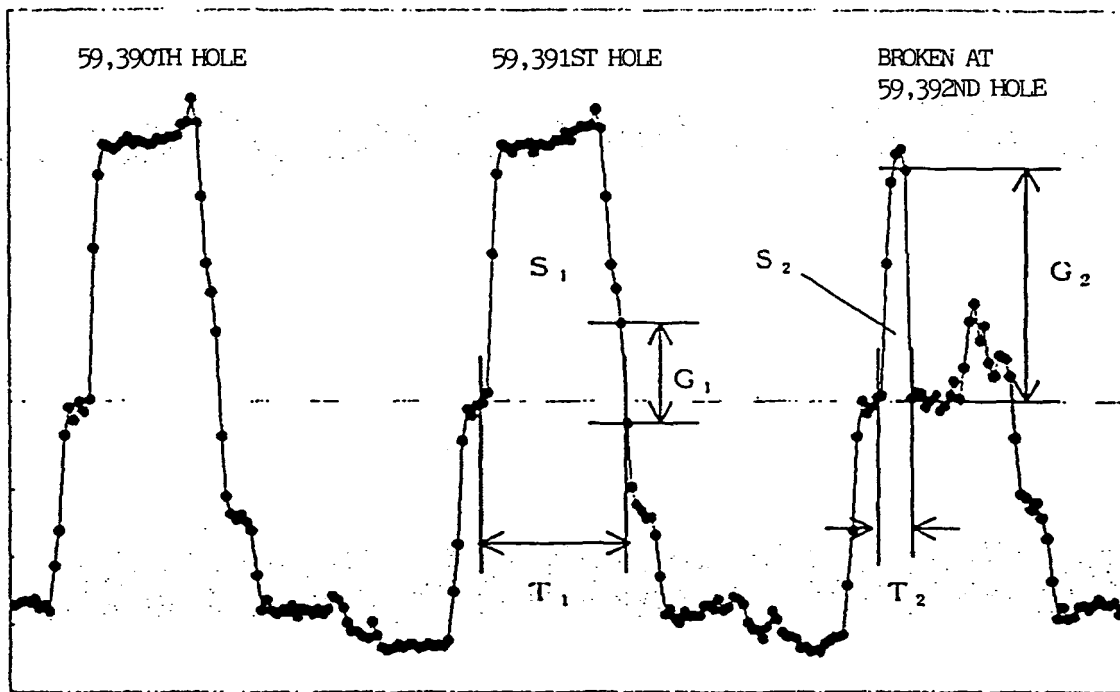


FIG. 6

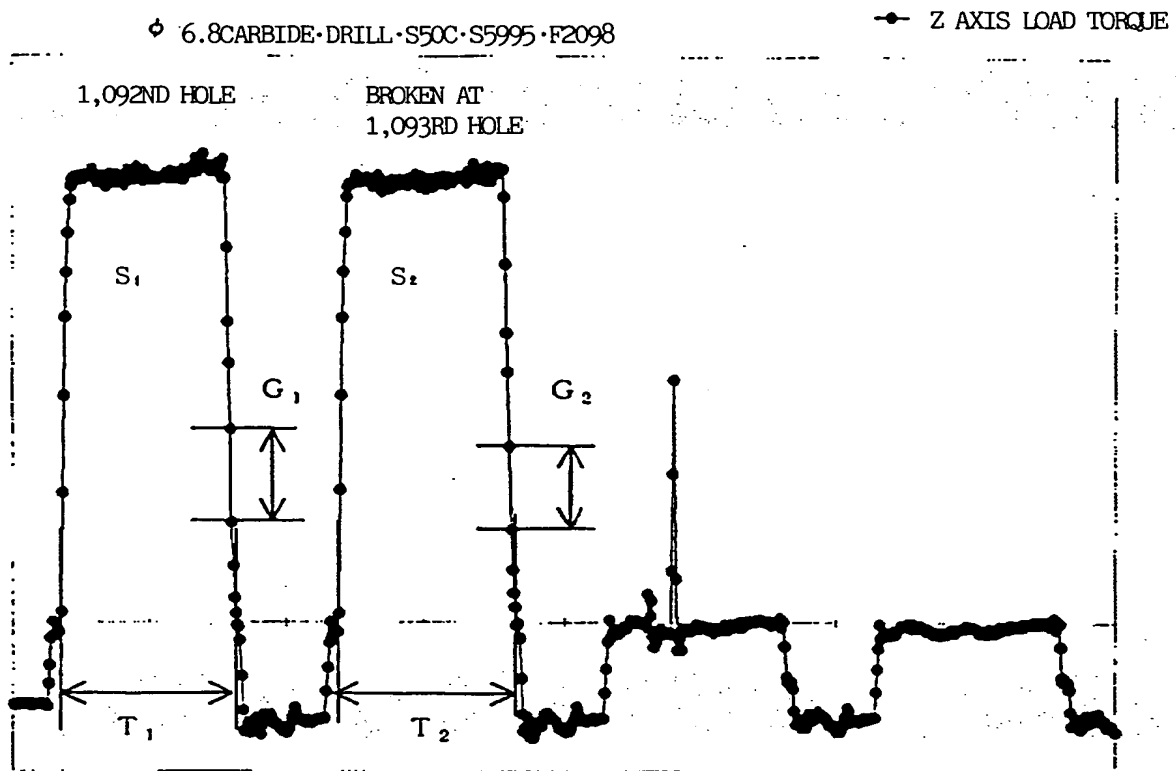


FIG. 7

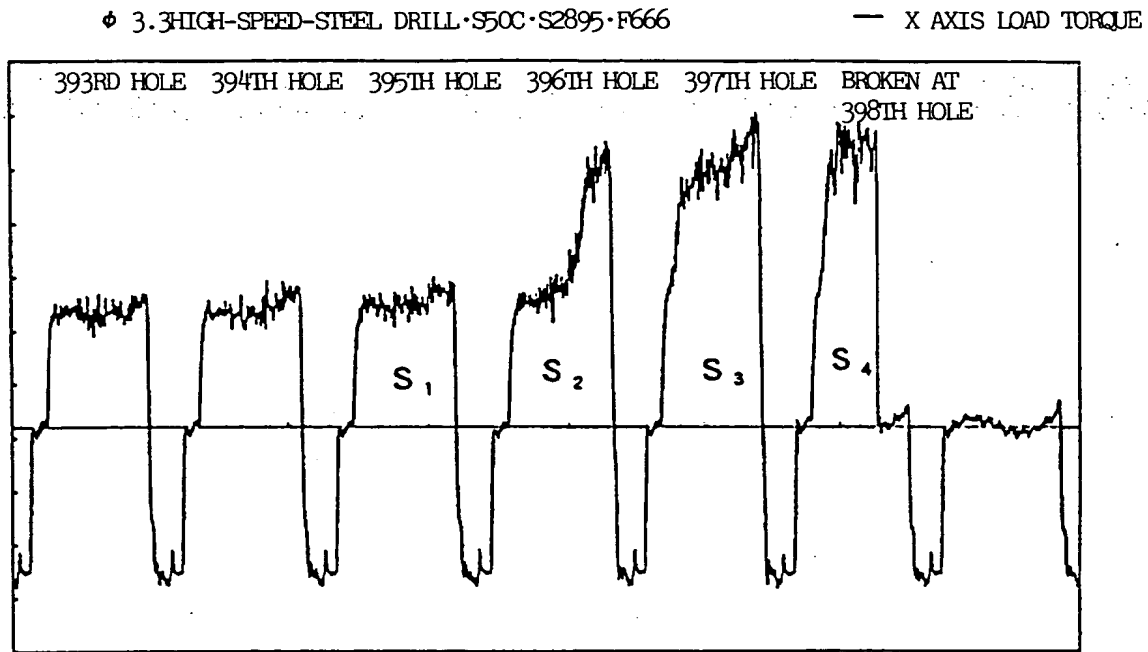


FIG. 8

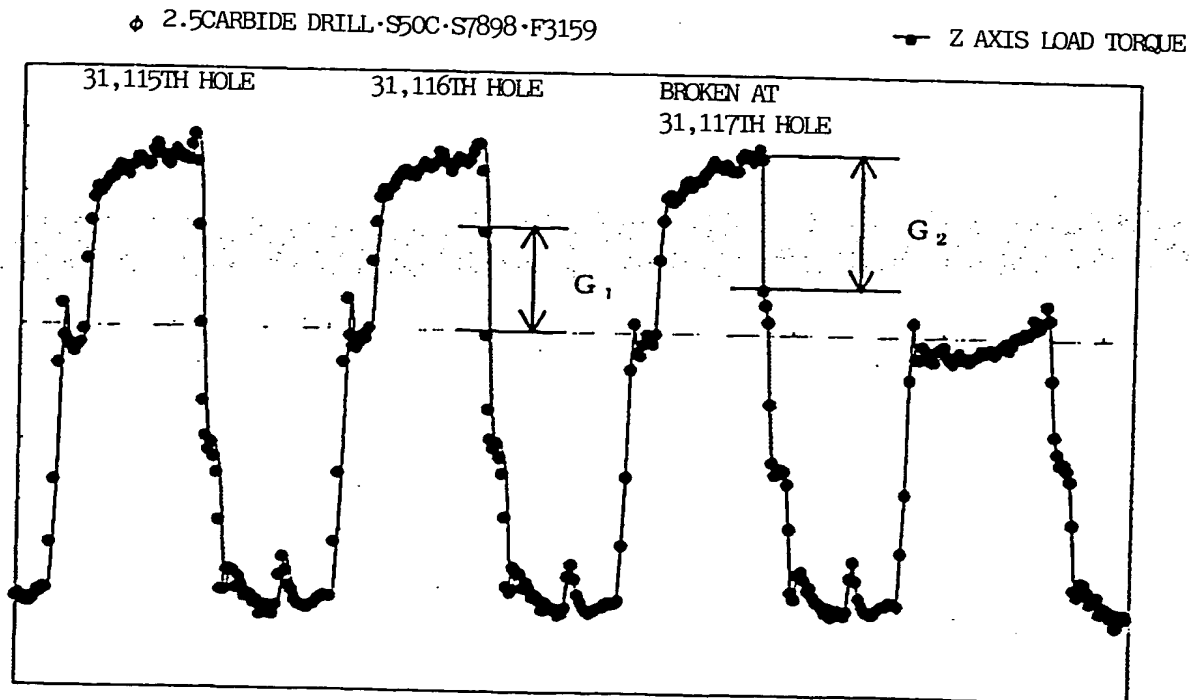


FIG. 9

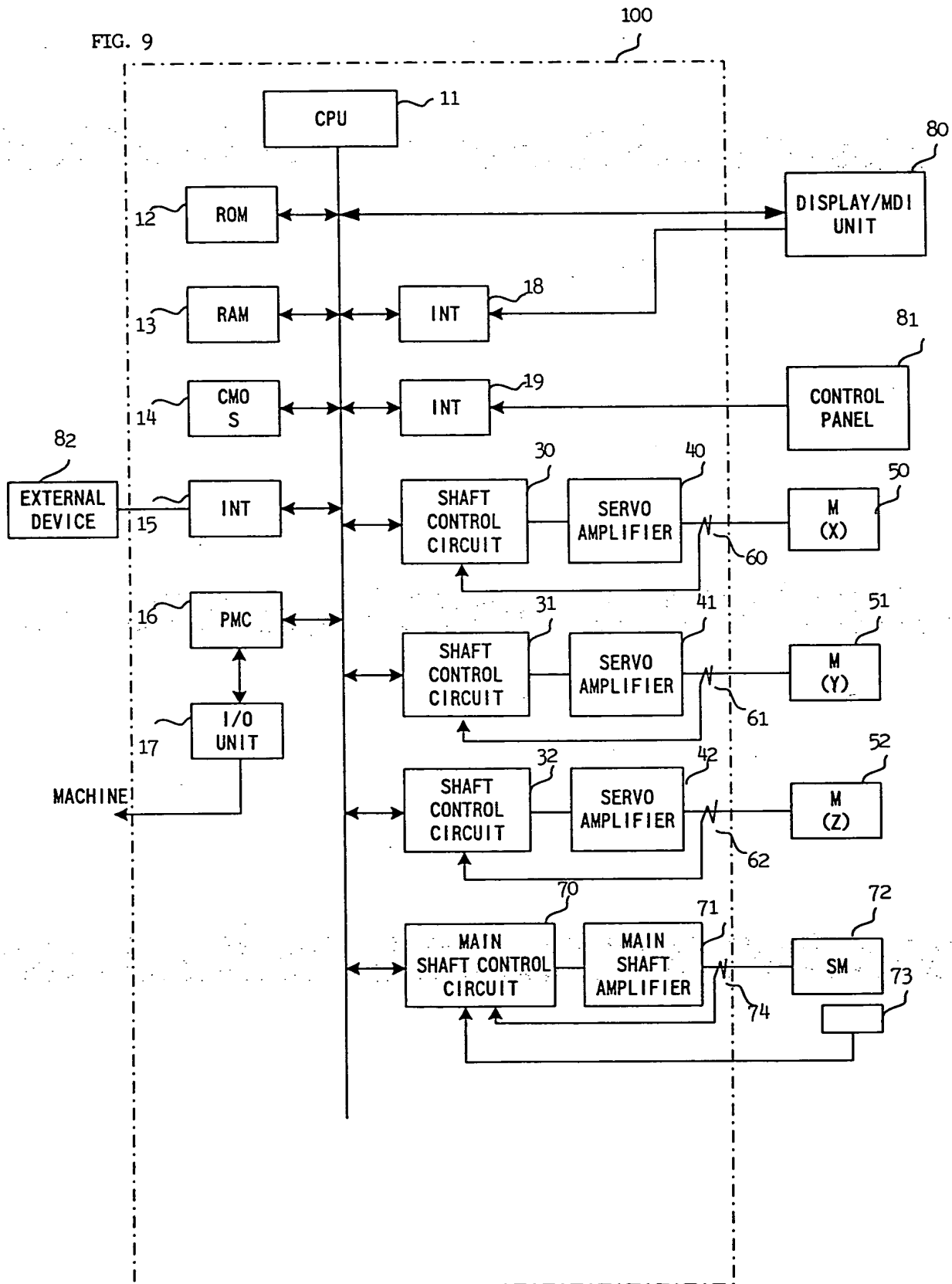


FIG. 10

